Technical data sheet Luxeplus
Pvdf coated aluminium

Basic alloys (chemical composition uni en 573-3 1996 norm)	**Physical estate** (in accordance with UNI EN 485-2 norm)
3005 – 3105 – 3003	H42 – H44 – H46 – H47 – H48

Allowance tolerance

width

35-200 mm	201-350 mm	351-600 mm	601-900 mm	901-1500 mm
+/-0.2	+/-0.3	+/-0.5	+/-1.0	+/-1.5

Thickness (without paint)

Punctual	Average*
0.200 -3.000 mm	0.200 -3.000 mm
+/- 8%	+/-6%

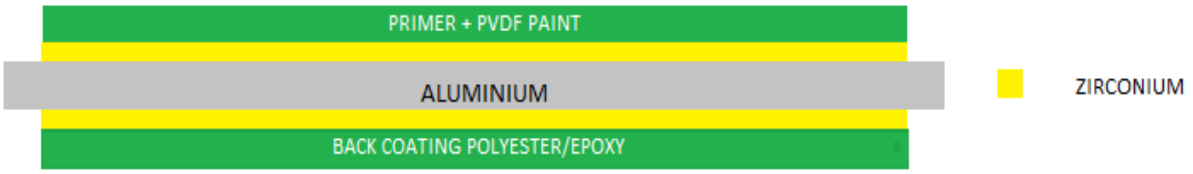
**:average tickness =(D^2-d^2)xπ/(4000xL)*
D= outside diameter mm; d= inside diameter mm; L= length mt.

Chemical pre-treatment

Before being painted, the aluminium undergoes two chemical degreasing processes and the zirconium treatment

Paint features

Painted side	Type of resin	Film basis weight	Film thickess	Gloss
Upper side	Primer + Pvdf paint	≈ 30 g/m^2	≈ 24 μm	Max 35°
Underside	Back coating polyester/epoxy	≈ 5 g/m^2	≈ 4 μm	30-90°



Technical characteristics of the painted surface

Adherance	AICC n°1 (erichsen +strap with adesive tape) AICC n°7 (checks method)	
Resistance to Metilethilchetone	100 double shots	
“T bend” test	0T – 2T	
Shot at 50 cm	ok	
Gloss test	Unit 10 20-39	Tolerance +/-3 +/-5
Colour measure	white Pastel colour Metallic colour	ΔE ≤ 0.5 ΔE ≤ 1.0 ΔE ≤ 1.75
Saline spray	Depending on basic alloys used (astm D714-85)	
Saline acetic spray	Depending on basic alloys used	
U.V. test	Good (1000 h)	
Reaction to fire	A1 (EN 13501-1-2018)	

Painted according to UNI EN 1396
Protective film features: protective film 50/70 micron UV resistant